



Dart Aerospace Ltd.
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DSI 9653-011
Job Sheet 183445



Part No: DSI 9653-011

Job Qty: 2 ea

Part Name: Tow Ring Mod



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/1/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 13.05.27 AS PER DWG REV.A DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/1/18	10/1/18	0.00	0.00	Start Up Stores/Pkg-2		SEP 19 2018
110	Packaging	2 pcs	10/1/18	10/1/18	0.00	0.00	Packaging1-5		OCT 11 2018
120	QC	2 pcs	10/1/18	10/1/18	0.00	0.00	QC4		OCT 12 2018
125	DC	2 pcs	10/1/18	10/1/18	0.00	0.00	DC		OCT 12 2018
130	Packaging	2 pcs	10/1/18	10/1/18	0.00	0.00	Packaging3-2		OCT 12 2018
140	QC21-FG	2 Ea	10/1/18	10/1/18	0.00	0.00	QC21		OCT 12 2018

Part Op 125 - Photocopy bluefile & type labels per PPP DSI9653-011 CHG001
Descriptions: 130 - Identify and pack for shipping as per PPP DSI9653-011

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4C5A	Bolt	2 Ea (1 ea)	90-Start up Operation	5019402
CCR264SS3-3	Cherry Rivet	4 Ea (2 ea)	90-Start up Operation	5082912
CR3522-4-3	Rivet	24 Ea (12 ea)	90-Start up Operation	5084875x8 FM132921
D4825-041	Nut Plate Assembly	2 Ea (1 ea)	90-Start up Operation	5108453
D4859-1	Bushing	2 Ea (1 ea)	90-Start up Operation	5108583
NAS1149C0463R	Washer	2 Ea (1 ea)	90-Start up Operation	5053953

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4C5A	2	59	0
	CCR264SS3-3	4	316	0
	CR3522-4-3	24	25	0
	D4825-041	2	4	0
	D4859-1	2	7	0
	NAS1149C0463R	2	332	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS ☐ Mid-tube ☐ Cross tube ☐ " " " " ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Packaging Supplier ☐ Engineering ☐ Quality ☐ Other
Description 		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval

Part: DSI 9653 - 011
 Job No: 183445
 Serial No/Batch: S111624
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: TC STC SH98 - 4 Issue 2 of 4 SA00475SE 15/10/28, EASA STC

DART AEROSPACE
 Container No: S111624
 DART Aerospace Ltd.
 1270 Alenden Street
 Hawkebury, ON K6L 1K7
 TEL: 1 813 632 - 5200
 Email: sales@dartero.com
 www.dartaerospace.com

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced	☐	Temperature/Cu...	☐
Bending	☐	Set-up	☐
Centre Not Concentric	☐	BOM/Route	☐
Cracks	☐	Broken/Damage/Defect	☐
Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Cuffs	☐	Contamination	☐
Crushing	☐	Countersink	☐
Heat Treat	☐	Cut Too Short	☐
Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Marks/Chatter	☐	Drill Holes	☐

Loss/Surge	☐	Positioned Wrong	☐
Program	☐	Outside Dimensions	☐
Grain	☐	Over/Under tolerance	☐
Weld	☐	Part Incorrect	☐
Wrong Stock Pulled	☐	Part Lost/Missing	☐
Out of Sequence	☐	Part Moved	☐
Off-set	☐	Drawing	☐
Mislabeled	☐	Finish	☐
Fit/Function	☐	Misread	☐
Misaligned/off center	☐	Turning Sequence	☐

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D206-642 REV. P
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV.5

REF. FAA STC: SA00475SE

REF. CANADIAN STC: SH98-4

REF. EASA STC: EASA.IM.R.S.01320

1.0 PURPOSE:

The purpose of this Dart Service Instruction is to provide customers with a kit to upgrade the Nutplate Assembly that retains the Tow Ring on their D206-642-XXX Skidtubes.

This kit also contains a bushing for modifying the Tow Ring itself to prevent the bolt from backing off.

Each kit contains materials for modifying (1) D206-642-XXX Skidtube.

2.0 PARTS LIST:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI9653-011	TOW RING MOD KIT
1	D4825-041	NUT PLATE ASSY
1	D4859-1	BUSHING
1	AN4C5A	BOLT
1	NAS1149C0463R	WASHER (OR AN960C10L)
2	CCR264SS3-3	CSK BLIND RIVET (STAINLESS STEEL)
12	CR3522-4-03	CSK BLIND RIVET (MONEL)

3.0 WEIGHT AND BALANCE:

There is a negligible weight change associated with this modification.

A	NEW ISSUE	AJS	13.05.07
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC	
DRAWN	AJS	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9653	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TOW RING MOD	NTS
DATE	13.05.07	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Change Record

PAGE 1 OF 1

Part Number: DSI 9653-011

Description: TOW RING MODIFICATION INSTALLATION[illegible]